

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017719**Date Inspected:** 20-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#10

**ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10**

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 44 located on Bike Path, top cover plate to side plate BK004A1 – 027. Welder is identified as 0500363. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2214 – B – u2. (See attached photo)

Weld joint # 41 located on Bike Path, BK004A6 – 027. Welder is identified as 040302. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 44 located on Bike Path, top cover plate to side plate BK004A1 – 027. Welder is identified as 057258. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2214 – B – u2.

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Weld joint # 42 located on Bike Path, BK004A6 – 027. Welder is identified as 057180. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

### Heat Straightening:

Heat Straightening being performed on Bike Path identified as BK004A - 27 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Yuan Hui Gang present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 9656.

BAY#11

### ORTHOTROPIC BOX GIRDER (OBG) AT BAY#11

This QA Inspector observed the following work in progress

#### Fluxcored Arc Welding (FCAW):

Weld joint # 13 located on Bike Path BK004A2 – 017. Welder is identified as 040723. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 43 located on Bike Path BK004A1 – 022. Welder is identified as 040723. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4c – F.

Weld joint # 08 located on Bike Path BK004A2 – 017. Welder is identified as 040723. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 43 located on Bike Path BK004A1 – 022. Welder is identified as 040654. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4c – F.

#### Shielded Metal Arc Welding (SMAW):

Weld joint # 022 located on Bike Path, BK004A6 – 022. Welder is identified as 040655. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

Weld joint # 115 located on Bike Path, BK004A6 – 022. Welder is identified as 041271. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

### Heat Straightening:

Heat Straightening being performed on Bike Path identified as BK004A - 23 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Xu Jie present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 9669.

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(See attached photo)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No Relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho- 15002048250, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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